

Work Order ID 74651

Wednesday, October 05, 2011 6:46:08 AM

ASAP



Item ID: D4202-1

Accept



Setup Start



Revision ID:

Item Name: Spacer

Stop



Start Date: 10/4/2011 Start Qty: 110.00

Required Date: 10/14/2011 Req'd Qty: 110.00



Cust Item ID:

Customer:



Reference:

Approvals:

Process Plan: *U*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4202

B Rev C 11.12.14

100

0.00



Hardinge CNC LATHE SMALL

0.00

Hardinge

Memo

Hardinge CNC Lathe Small

1- Machine as per Folio FB015

FOLIO REV: *AA*

DWG REV: _____

2- Deburr

0.00

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

SD 11/10/06

110 φ

SD 11/10/06

110 φ

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Page 2

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B.A 11/10/06

110 0

125

0.00



Purchasing

Memo

0.00

Purchasing

issue PO 15112
ship to metcor to heat treat to condition T4

11-10-7
110

126

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

11/14/25 110

Work Order ID 74651

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Page 3

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Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 110.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

127

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: 46

0.00



Packaging

Memo

0.00

Packaging

STOCK IN SKIDTUBE CELL

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

★ Acceptable
to D4202 Rev. C
CP 11/12/14



11-11-23



11/12/14

ME

11-11-23

POSITIVE RECALL

EFFECTIVE 11/05

AUTH

RELEASED

DATE

11/16/24

Picklist Print

Wednesday, October 05, 2011 6:46:06 AM

Page 1

Work Order ID: 74651

Parent Item: D4202-1

Parent Item Name: Spacer



Start Date: 10/4/2011

Required Date: 10/14/2011

Start Qty: 110.00

Required Qty: 110.00

Comments: IPP REV:A NEW ISSUE 10-12-07 JLM VERIFIED:DD IPP
REV:B AS PER REV B 11-04-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T0.500W.058

Purchased

No

f

73.9000

40.53

11/10/06



6061-T6 RD Tube .500 x.058W



Location

Loc Qty

Loc Code

MAT014

73.9

✓ 117084

38.2

✓ 117890

1.1

✓ 118702

34.6

2.958'

36'

Linda Lacelle

From: Eric Charbonneau <echarbonneau@dartaero.com>
Sent: August 3, 2011 12:46 PM
To: 'Linda Lacelle'
Subject: RE: swaging

D4202 with 6061-T6 .500 x .058w
Eric

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: August 3, 2011 11:53 AM
To: Eric Charbonneau
Subject: swaging

Do I use the D4202 drwg? What wall thickness have we finally decided on pls?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd
Hawkesbury, ON
Phone: 613 632 9577
Fax: 613 632 1053
Cell: 613 676 1655

40 pcs.

Ø0.500

Ø0.402
REF

△ 0.049

0.058

AP 11.10.06

D4202-1 SPACER

4.145^{+0.030}
-0.010

74651

.500 x .058

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM TUBING PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8 △
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

RELEASED
2011-03-31

B	0.049 WAS 0.058. REASON: FACILITATE MFG	MB	11.03.22
A	NEW ISSUE	CP	10.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D4202	SHEET 1 OF 1
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SPACER	NTS
DATE	11.03.22	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR OTHERWISE USED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Tél. : 450-473-1884
Télécopieur / Fax : 450-491-5498
Télécopieur / Fax : 450-491-6454

Certificat de conformité Certificate of Compliance

BON DE TRAVAIL / CHARGEMENT	order	lot
	170205	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K8A 1K7

COMMANDE DU CLIENT customer po.	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
230792		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

□

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	35 - 43 %IACS	110	37.5 - 38.5 %IACS
HARDNESS	60 HREW MIN	110	61 - 65 HREW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
110	4	D4202-1 (110) D4202-1 B74651 CONTENANT: 1 BOITE DE CARTON

COMMENTAIRES / comments

INSPECTEUR / inspector:

DATE: 2011-10-21

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
170205	1

CLIENT / customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	BON DE LIVRAISON DU CLIENT customer shipper no.	MATÉRIEL material	CODE DE TRAITEMENT mat'l heat code	NUMÉRO DE LOT lot number
230792		AL-6061		

SPÉCIFICATIONS DU PROCÉDÉ

processing specifications

SOL ANNEAL

SINGLE AGING TO CONDITION T42

☐

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
CONDUCTIVITY	35 - 43 %IACS	110	37,5 - 38,5 %IACS
HARDNESS	60 HREW MIN	OK 11.10.26 110	61 - 65 HREW

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
110	4	D4202-1 (110) D4202-1 B74651 CONTENANT: 1 BOITE DE CARTON

Operation	Temp. spécifiée Specified Temp	Temps de trempe Spécifié Specified Soak Temp	Atmosphere	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
1,00 CONT. INIT.										
2,00 Degrease										
3,00 PREPARING	COMPTAGE									
4,00 PREHEAT 1	529°C	0:45	air			701				
5,00 WATER TEM										
6,00 SOL ANNEAL	529°C	0:35	AIR		WATER 32MAX	701				
7,00 QUENCHDE										

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC, J7R 5A8

Tel: 450-473-1884 / Fax: 450-491-5498

Certificat de Conformité Détaillé

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BON DE TRAVAIL order	CHARGEMENT load
170205	1

CLIENT / customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

Operation	Temp. spécifiée Specified Temp	Temps de trempage Spécifié Specified Soak Temp	Atmosphere	Carbone Carbon Potential	Q-Media Q-Temp	Four # Furnace #	Date Départ Start Date	Heure d'entrée Time In	Heure de sortie Time Out	Date Complétée Date complete
8,00 WATER TEM										
9,00 PREPARING										
10,00 AGE HARDEN		96:00								
11,00 HARDENING										
12,00 CONDUCT										
13,00 FINAL INSP							10-21-2011			10-21-2011

COMMENTAIRES / comments

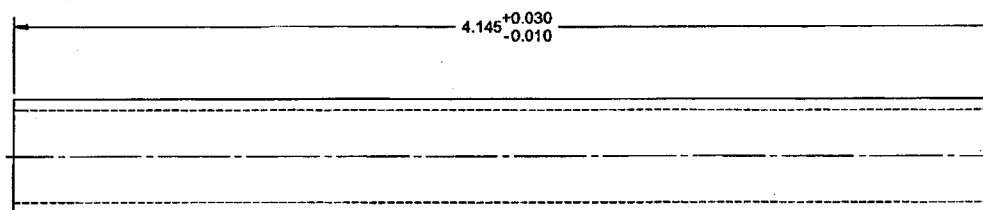
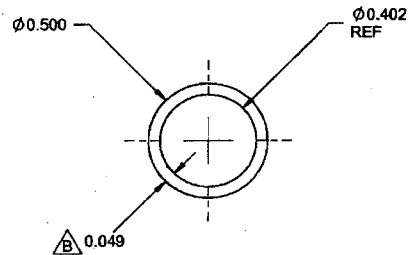
APPROUVÉ par / Approved by:

Vincent Lavoie



DATE: 2011-10-24

/ Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client. / We certify that all the information on this report is exact and in accordance with the order requirements.



D4202-1 SPACER

74651

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM TUBING PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC M6061T6T0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

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A	NEW ISSUE	CP	10.09.22
REV.	DESCRIPTION	BY	DATE
DESIGN	DP		
DRAWN	AS		
CHECKED	AS		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.03.22		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4202** REV. B
TITLE **SPACER** SCALE NTS
SHEET 1 OF 1

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